

Work Order ID 110055

110055

Page 1

December-17-13 9:07:08 AM

Item ID: D2594-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: O-Ring
 Start Date: 12/17/13 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: H Date: 12-17 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2594	Rev C								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>22468</u> Purchase as per Dwg D2594 Possible P/N: Parker 2-011 Material release note is required								<u>CL 12/12/23</u> (100)
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								<u>10/13/14/24</u> (100)
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									<u>100</u>

DAS

27

9-89

12/11/17

Work Order ID 110055

December-17-13 9:07:08 AM

110055

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Item ID: D2594-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: O-Ring

Start Date: 12/17/13 Start Qty: 100.00

100

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: ~~SK~~

0.00

130

Packaging

Memo

0.00

Packaging

100% 14-1-7

DAS
26
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14-01-8

14-01-8

Picklist Print

December-17-13 9:07:08 AM

Page 1

Work Order ID: 110055

Parent Item: D2594-3

Parent Item Name: O-Ring

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP B04.06.08Reformat; Added Powder CoatKJ/JLM
IPP C 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS28775-011 O-Ring		Purchased	No			100	Each	0.0000	1	100			

13/14/26 100

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

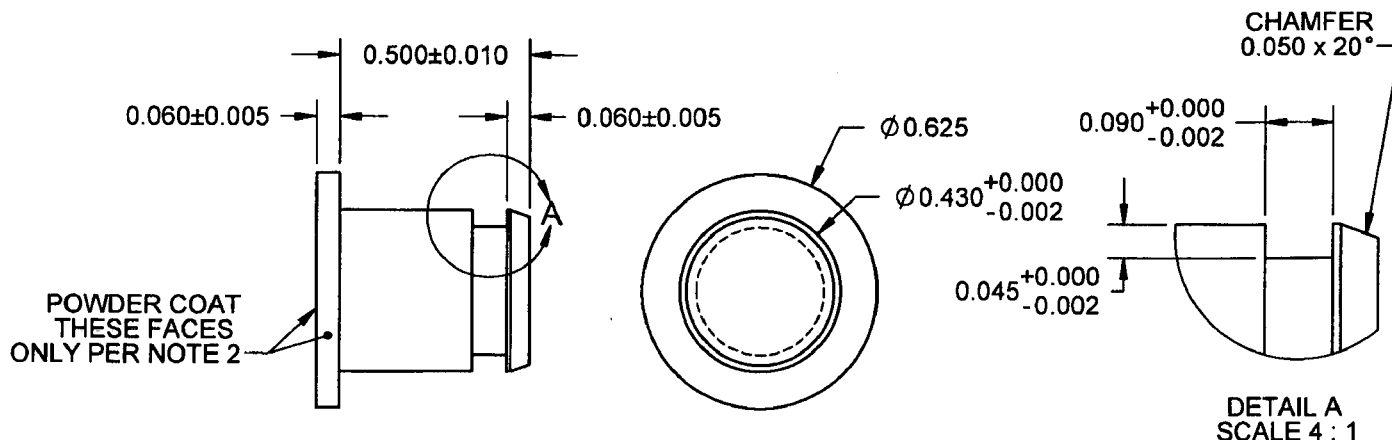
Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



DESIGN <i>HA</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

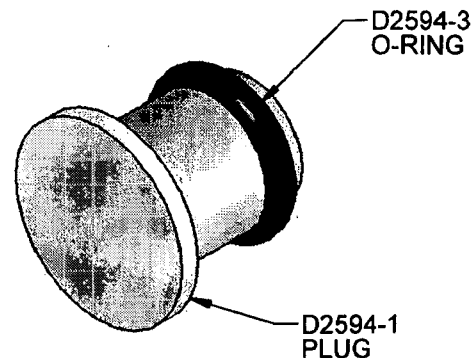
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 \triangle
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 \triangle

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

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ACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE

Purchase Order ID: **EC**Purchase Order Date: **12/23/2013**PO Print Date: **12/23/2013**

Page Number 7 of 9

Order From :

VU-EC001

EAST COAST AVIATION SUPPLIES, INC.
399 EAST DRIVE
MELBOURNE, FLORIDA 32904
USA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

1-321-727-0047

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Michael Gregoire

Customer POID

Customer Tax

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Total:

\$22.

21 MS27039-1-40

Screw

12/30/2013

25.00

✓

\$1.20

\$30.

Yes

Each

12/30/2013

306

Line Total:

\$30.0

22 MS28775-011

O-Ring

12/30/2013

100.00

Yes

\$0.16

\$16.0

Each

12/30/2013

NOTE

Require minimum 60% shelf life. Date of manufacture and cure date required.

B110055

AS PER DWG D2594 REV. C

Line Total:

\$16.00

23 MS35206-226

Screw

12/30/2013

300.00

✓

\$0.06

\$16.50

Yes

Each

12/30/2013

288

Note:

12/23/2013

East Coast Aviation Supplies, Inc.

399 East Drive
Melbourne, FL 32904
USA
Ph: 321.727.0047, Fax: 321.727.7331

Packing Slip

Original

Invoice #: 470203
Date Printed: 12/20/2013
Time: 5:05:16 PM
of Items: 28
Page: 7

To:
DART AEROSPACE LTD.
ACCTS. PAYABLE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
CANADA

Ship To:
DART AEROSPACE LTD.
ATTN: RECEIVING
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7
CANADA

ATTN: MICHAEL
Ph: 613.632.9577 Fax: 613.632.1053

Invoice Date: 12/20/2013
Order Date: 12/20/2013
Ship Date: 12/20/2013
Sales Order: 420776
Customer #: 16754

Terms: NET 30
Cust. PO#: PO22468
FOB: MELBOURNE, FL

AWB: 5674 3662 5521

Weight: 23
of Boxes: 1
Shipment #: 1

Ship Via: INT'L PRIORITY

ECAS Contact: BILL AYERS

Item	Part Number/Description	Shipped	BackOrd	CD	Unit Price	UoM	Total Amt
21	MS27039-1-40 STRUCTURAL SCREW ECCN#: 9A991 SCHB#: 7318.15.4000 MFR: MAC LOT: 41894 QTY: 25	25.00	0.00	NE			
22	MS28775-011 O'RING ECCN#: EAR99 SCHB#: 4016.93.1010 MFR: PARKER LOT: 0081002918 QTY: 100	100.00	0.00	NE			
23	MS35206-226 SCREW ECCN#: 9A991 SCHB#: 7318.15.4000 MFR: CRESCENT LOT: 80239 QTY: 300	300.00	0.00	NE			
24	NAS1149C0332R WASHER S/S	2400.00	0.00	NE			

Special Instructions:

East Coast Aviation Supplies, Inc.
CERTIFICATE OF CONFORMITY

Original

No: 470203

Bill To:

Ship To:

ORIGINAL

DART AEROSPACE LTD.
ACCTS. PAYABLE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7

DART AEROSPACE LTD.
ATTN: RECEIVING
1270 ABERDEEN STREET
HAWKESBURY, ON K6A1K7

Customer PO

Ship Date

Airway Bill Number

PO22468

12/20/2013

5674 3662 5521

Part No.	Description	Cond	Qty	S/L	
MS28775-011	O'RING	NE	100	33	
MFR: PARKER LOT: 0081002918	ECCN#: EAR99 SCHB#: 4016.93.1010				
MS35206-226	SCREW	NE	300	19	
MFR: CRESCENT LOT: 80239	ECCN#: 9A991 SCHB#: 7318.15.4000				
NAS1149C0332R	WASHER S/S	NE	2400	34	
MFR: SUPERIOR LOT: 518574-2	ECCN#: 9A991 SCHB#: 7318.22.0000				
NAS1149DN332J	WASHER	NE	500	14	
MFR: ANILLO LOT: W2410	ECCN#: 9A991 SCHB#: 7616.10.8000				
NAS1149F0332P	WASHER	NE	2500	67	
MFR: SUPERIOR LOT: C129882-2	ECCN#: 9A991 SCHB#: 7318.22.0000				
NAS1515H3L	NYLON WASHER	NE	400	15	
MFR: IGM LOT: 48955	ECCN#: EAR99 SCHB#: 3926.90.4500				
NAS1515H4L	NYLON WASHER	NE	350	7	
MFR: IGM LOT: 52522-01	ECCN#: EAR99 SCHB#: 3926.90.4500				

CONDITIONS: NE - New NS - New Surplus OH-Overhauled RP-Repaired SV-Serviceable

We hereby certify that the items that are a part of this Purchase Order have been visually & dimensionally found to conform to all applicable standards, drawings & specifications. The liability of ECAS is limited to replacement of any item which is rejected because of a defect in material or workmanship if notified within 30 days & liability shall not exceed the invoice value. Such replacement shall constitute satisfaction of all liability.

Signed:

For and on behalf of EAST COAST AVIATION SUPPLIES, INC.

Insp.
#2

Inspectors Stamp